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Re Print

D206-642-541
Job Sheet 195722



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV G IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP Rev:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/5/19		0.00	2.17	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		TF
							Skidtubes - 6		BE
							Skidtubes - 7		
114	QC 5	1 pcs	7/5/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	JUL 0 2 2019
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 48		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
116	QC 10	1 pcs	7/5/19		0.00	0.00	QC 5 - 30		
							QC 5 - 40	DAS	
							QC 10 - 10	DAS	
							QC 10 - 18	9-89	
							QC 10 - 24	9-89	JUL 0 2 2019
							QC 10 - 43		

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120 Handfinish - 1-1 Chemical- B4B	1 pcs	7/5/19	0.00 0.68	QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
130 QC 7	1 pcs	7/5/19	0.00 0.00	Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

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150 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 2.08	QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
160 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
170 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 2.17	Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	ALLG
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
180 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
190 Skidtubes - 4 - B4B	1 pcs	7/5/19	0.00 2.75	Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	

200 QC 5	1 pcs	7/5/19	0.00 0.00	Skldtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	JUL 26 2019 DAS 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 10 - 10	
				QC 10 - 18	
210 QC 10	1 pcs	7/5/19	0.00 0.00	QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	JUL 26 2019 DAS 50
				QC 10 - 58	9-89
				QC 10 - 9	
220 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.45	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	JUL 27 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	7/5/19	0.00 0.40	Spray Paint - 1 - B4B	19-8-11
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
240 QC 14	1 pcs	7/5/19	0.00 0.00	QC 14 - 15	19-8-19
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				Handfinish - 3 - 1 - B4B	19-8-19
				Handfinish - 3 - 2 - B4B	
244 Handfinish - 3-1- WingWalk- B4B	1 pcs	7/5/19	0.00 0.50	Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
				QC 3 - 10	
				QC 3 - 13	
246 QC 3	1 pcs	7/5/19	0.00 0.00	QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	

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				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	BEB 19-08-19
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 24	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	7/5/19	0.00 0.45	Handfinish - 4 - 1 - B4B	M 19-8-19
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	DAS
				QC 5 - 49	19
				QC 5 - 51	9-89
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 -	

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				B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
280 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
290 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
295 DC - 1 - B4B	1	7/5/19	0.00 0.00	DC - 1 - B4B	AUG 27 2019
	pcs			DC - 2 - B4B	
300 QC 21 - FG	1	7/5/19	0.00 0.00	QC 21 - FG - 21	AUG 27 2019
	pcs			QC 21 - FG - 70	
				QC 21 - FG - 53	PC FG Pack

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: 138989/13011 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

114 - (QC5- Inspect part completeness to step on W/O)
116 - (QC10- Inspect visual per QSI004- ground welds)
120 - (Chemical Conversion Coat per QSI005 4.1)
130 - (QC7-Inspect Chemical Conversion Coat)
150 - (Skidtubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours)
160 - (QC5- Inspect part completeness to step on W/O)
170 - (Skidtubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding
180 - (QC5- Inspect part completeness to step on W/O)
190 - (Skidtubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274. ****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.
200 - (QC5- Inspect part completeness to step on W/O)
210 - (QC10- Inspect visual per QSI004- ground welds)
220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch
230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw,. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5199127 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5198581
240 - (QC14- Inspect Spray Paint)
244 - (Wing Walk as per dwg QSI005 4.4 Batch 5185147)
246 - (QC3- Inspect Part Finish)
250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.
260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts
270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
280 - (QC5- Inspect part completeness to step on W/O)
290 - (Identify as per dwg & Stock Location: _____) Location : FG073
295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005
300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	5109144
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5043738
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	8191355
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5188442
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5199330
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5099573
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5111378860
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5147134
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5192134
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5057496
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5160603
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201500
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	519663d
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5164008
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5200829
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201318
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201108
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	520100-
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5193136
NAS1149C0332R	Washer	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5202076
NAS1149C0463R	Washer	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5104373
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	3	0
	D3285-1	1	13	0
150-Skidtubes - 2 - B4B	D3282-041	1	1	0
190-Skidtubes - 4 - B4B	D2649	12	128	0
	D3275-1	12	104	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	7,417	0
	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D3415-041	1	9	0
270-Handfinish - 4-2-Assembly-B4B	AN3C4A	80	848	0
	AN4C5A	1	55	0
	D2646	1	32	0
	D3413-1	1	17	0
	D3537-1	9	56	0
	D3537-3	1	18	0
	D3672-1	2	1,673	0
	D4956-15	1	4	0
	D4956-23	1	10	0
	D4956-35	1	8	0
	D4956-39	1	1	0
	NAS1149C0332R	80	2,818	0
	NAS1149C0463R	1	279	0
Part Specifications				
Specifications could not be found.				

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Qty	Qty	Qty	Part Number	Description
443	443	443	D3274-041	SKIDTUBE ASSEMBLY
X	X	X	D3274-043	SKIDTUBE ASSEMBLY
X	X	X	D3274-048	SKIDTUBE ASSEMBLY (FOR PH)
1	1	1	D3260-1-240	EXTRUSION
1	1	1	D2848	AFT CAP
12	12	12	D2849	CROSS BOLT SPACER
12	37	12	D2775-1	CROSS BOLT SPACER
1	1	1	D3268-041	FLOAT WEB
1	1	1	D3285-1	CAP
1	1	1	D313-1	RING
1	1	1	D315-041	NUT PLATE
9	9	1	D337-1	WEARPAD
1	1	1	D337-11	WEARPAD
1	1	1	D337-3	WEARPAD
2	2	2	D337-9	WEARPAD
1	1	1	D337-11	WEARPAD
1	1	1	D337-18	WEARPAD
1	1	1	D337-28	WEARPAD
1	1	1	D337-35	WEARPAD
1	1	1	D337-39	WEARPAD
78	78	40	AL57-1032-130	INSERT (78 AL57-1032-130; AL57-1032-130; AL57-1032-130)
80	80	42	AN304A	BOLT
1	1	1	AN403A	BOLT
1	1	1	AN51160045R	WASHER (AN51160045R)
80	80	42	AN51160035R	WASHER (AN51160035R)
2	2	2	CP294-583-3	RIVET
2	2	2	CR3272-4-09	RIVET
2	2	2	MS273304-05	SCREW

GENERAL NOTES:

1. MATERIAL: N/A

2. FINISH: N/A

3. TOLERANCES: N/A

4. WEIGHT: 37.5 LBS

5. BREAK SHARP EDGES 0.008 TO 0.010 MAX

6. IDENTIFICATION: N/A

7. WEIGHT: 37.5 LBS

8. WELDING TO BE DONE PER DART QSI N/A.

9. ALL DIMENSIONS ARE TO CENTER LINES.

10. THERE SHALL BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT SCRUBS UP TO 0.002 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.190" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

11. BOND D3262-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/281

12. DRILL 0.0127 HOLES FOR AL57-1032-130 INSERTS USING D3274-172 BEFORE FINISH. INSTALL AL57-1032-130 INSERTS INTO HOLES WITH SIKAFLEX-241/281. ON -045; DO NOT DRILL HOLES OR INSTALL INSERTS FOR LOWER WEIGHT.

13. COAT ALL EXPOSED FASTENERS WITH LPS LUBRICANTIES "LPS PROCOYON" AFTER FINAL ASSEMBLY.

14. ON -045, APPLY COAT OF ROCKGUARD TO SKIDTUBE WHERE WEARPADS ARE INSTALLED.

15. TOLERANCES: N/A

16. WEIGHT: 37.5 LBS

17. BREAK SHARP EDGES 0.008 TO 0.010 MAX

18. IDENTIFICATION: N/A

19. WEIGHT: 37.5 LBS

20. WELDING TO BE DONE PER DART QSI N/A.

21. ALL DIMENSIONS ARE TO CENTER LINES.

22. THERE SHALL BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT SCRUBS UP TO 0.002 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.190" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

23. BOND D3262-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/281

24. DRILL 0.0127 HOLES FOR AL57-1032-130 INSERTS USING D3274-172 BEFORE FINISH. INSTALL AL57-1032-130 INSERTS INTO HOLES WITH SIKAFLEX-241/281. ON -045; DO NOT DRILL HOLES OR INSTALL INSERTS FOR LOWER WEIGHT.

25. COAT ALL EXPOSED FASTENERS WITH LPS LUBRICANTIES "LPS PROCOYON" AFTER FINAL ASSEMBLY.

26. ON -045, APPLY COAT OF ROCKGUARD TO SKIDTUBE WHERE WEARPADS ARE INSTALLED.

RELEASED
R 2016-07-26
ECU15-616

G	ADD -045 CONFIGURATION (FOR PH) ZN AS-4, AS-6 REVISE NOTE 2, 7 & 12, ADD NOTE 14 (ZN AS-1)	D8	16.04.25
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D208-442 REV Q	D8	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PART 12-258	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	08.12.19
C	ADD -045: NEW INSERTS	CP	05.03.18
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	RF	
DRAWN	AK	AK	
CHECKED	AK	AK	
MFG. APPR.	JLM	D3274	REV. G
APPROVED	D8		SHEET 1 OF 8
DE APPR.			SCALE
DATE	16.04.25		NTS

DART AEROSPACE USA, INC
ENGINEER, OR

DRAWING NO. D3274

TITLE SKIDTUBE ASSEMBLY

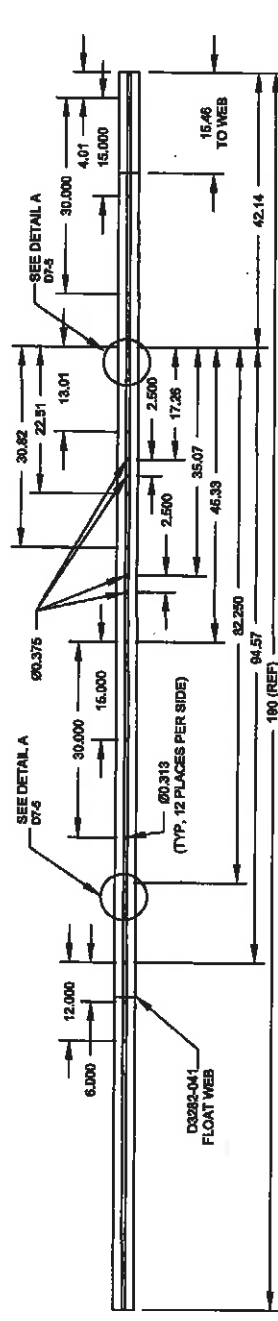
DATE 16.04.25

BY RF

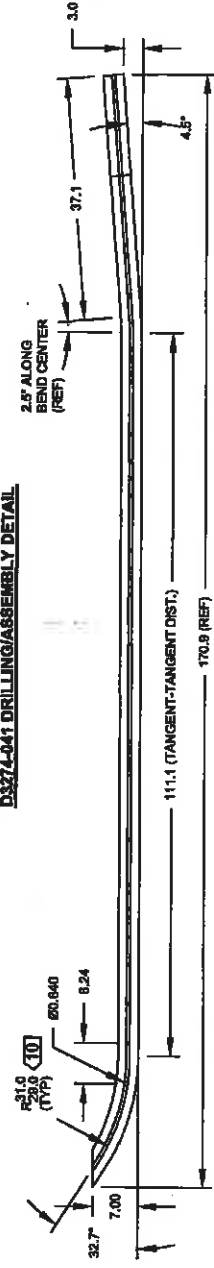
DATE 16.04.25

SCALE NTS

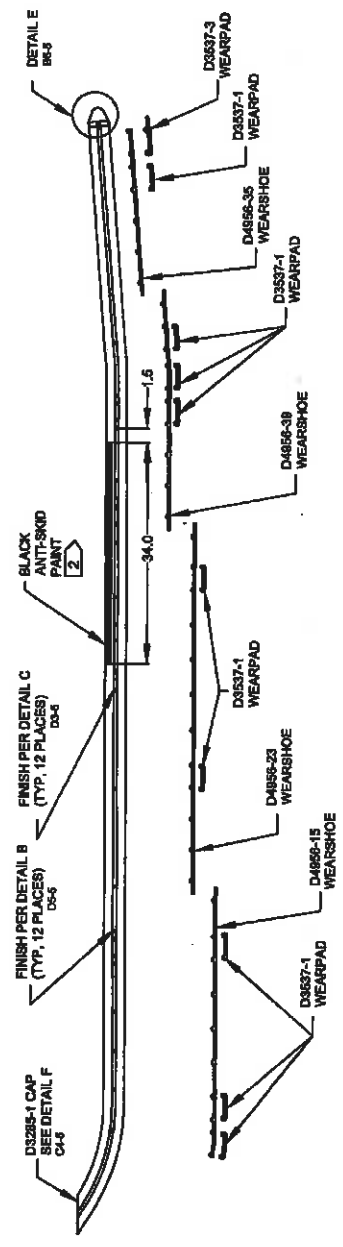
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

DESIGN	CP	RF	AK	JLM	DS	DATE	16.04.25
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CHECKED							
MFG. APPR.							
APPROVED							
DE APPR.							

DART AEROSPACE USA, INC
EUGENE, OR

DRAWING NO. D3274

REV. G

SHEET 2 OF 6

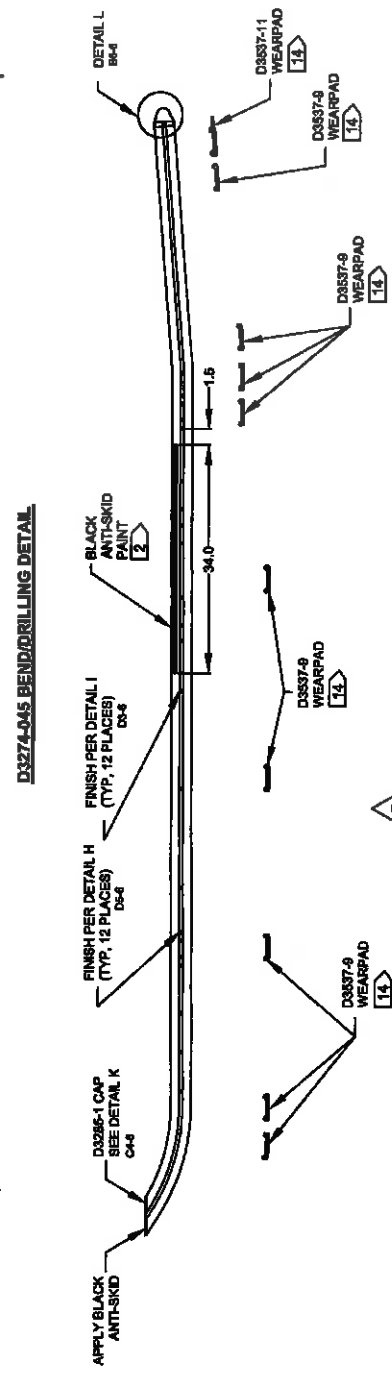
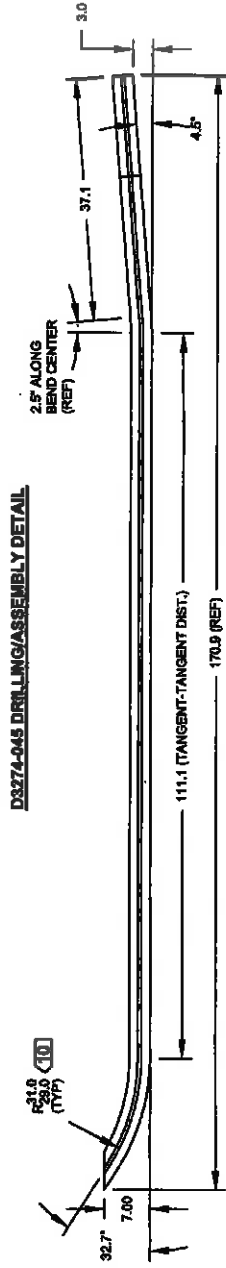
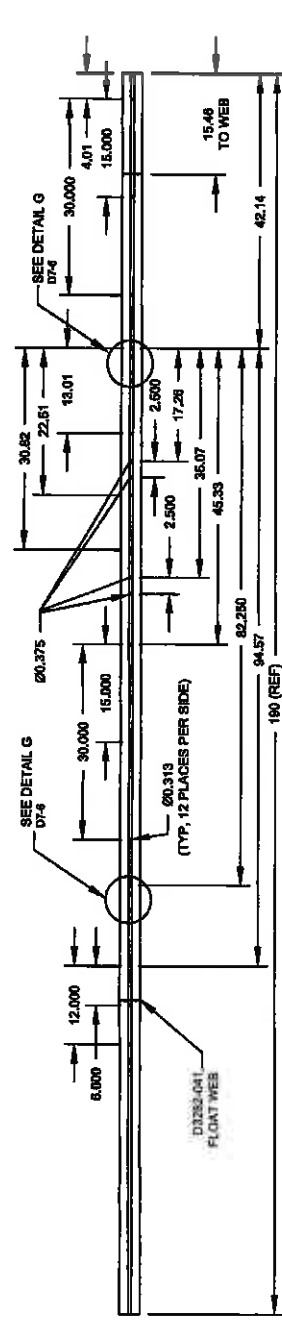
TITLE SKIDTUBE ASSEMBLY

SCALE NTS

DATE 16.04.25

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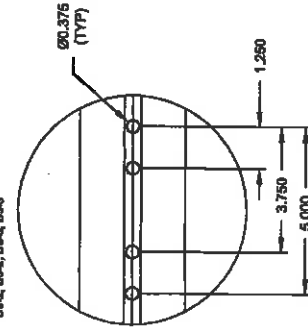


G D3274-04S SKIDTUBE ASSEMBLY
(SEE DETAIL J FOR WEARSHOE INSTALLATION)

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2016-07-26

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CHECKED	AK	DRAWING NO.	REV. G	SHEET 4 OF 8	
MFG. APPR.	JLM	D3274	SCALE		
DE APPR.	DIS	TITLE			NTS
		SKIDTUBE ASSEMBLY			
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DETAIL A: DRILL DETAIL
D6-4, D6-5, D6-6, D6-7



DETAIL B
B6-4, B6-5

FOR Ø0.375 HOLES ONLY

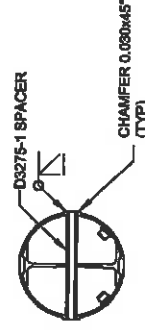


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:

1. CHAMFER HOLE 0.030x45°
2. INSERT D2848 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C/BORE TO Ø0.313±0.75 DEEP

DETAIL C
B6-2, B6-3

FOR Ø0.313 HOLES ONLY



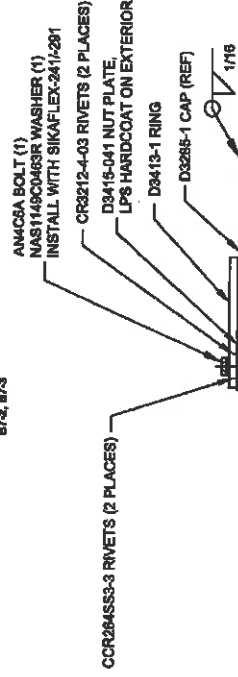
DETAIL D
A6-2, A6-3



- ALB7-1032-130 INSERT (1)
- ANSCAA BOLT (1)
- NAS1148C032R WASHER (1)
- (78 PLACES)

WEARSHOE/WEARPAD (REF)

DETAIL E: END FINISHING DETAIL
B7-2, B7-3



DETAIL F
B6-2, B6-3



- ANSCAA BOLT (1)
- NAS1148C032R WASHER (1)
- D3872-1 WASHER (1)
- (2 PLACES)
- INSTALL WITH SIKAFLEX-241/291

SEAL WITH
SIKAFLEX-241/291
ADHESIVE

Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2848 CAP
BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

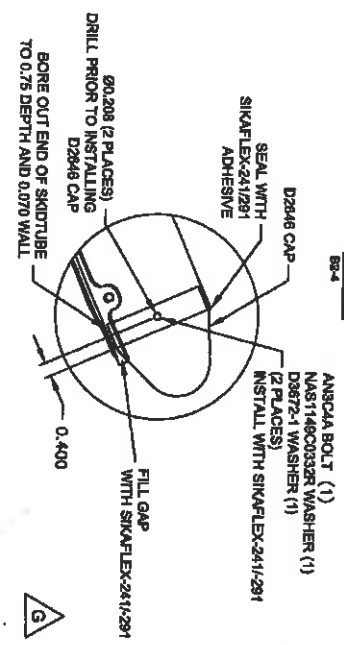
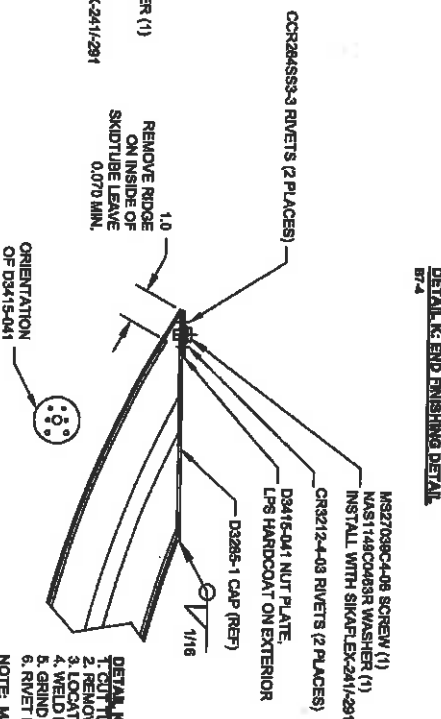
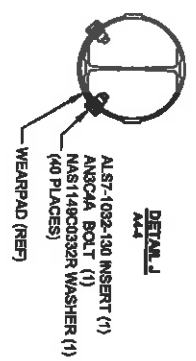
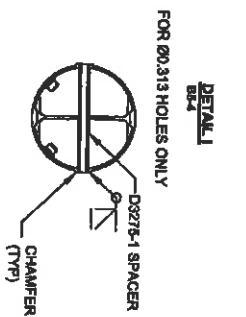
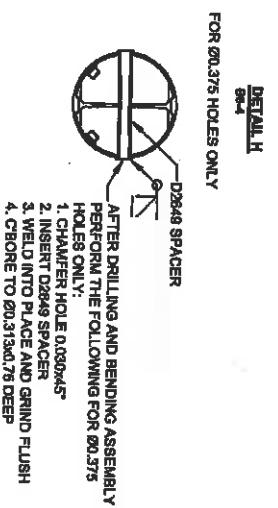
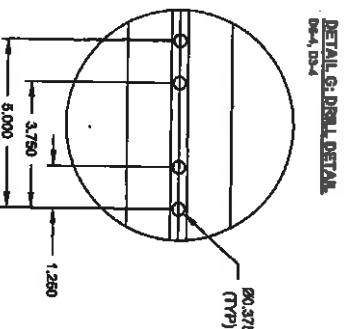


- DETAIL F NOTES
1. CUT TO BE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART Q381 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

-041/043 DETAILS

RELEASED
2016-07-26

DESIGN	CP	RF	AK	JLM	D3274	DART AEROSPACE USA, INC EVANSVILLE, IN
DRAWN						
CHECKED						
INFG. APPR.						
APPROVED						
DATE	16.04.25					
TITLE	SKIDTUBE ASSEMBLY					
SCALE	NTS					
REV. G	SHEET 5 OF 6					



DESIGN	CP	DART AEROSPACE USA, INC
DRAWN	RE	EUGENE OR
CHECKED	AK	REV. G
INFG. APPR.	JLM	D3274
APPROVED	DS	TITLE
DATE	16.04.25	SKIDTUBE ASSEMBLY
		SCALE
		NTS

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2016-07-26